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D3212-1
Job Sheet 213322



Part No: D3212-1

Job Qty: 7 pcs

DAS
21
9-89

Part Name: Replacement Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/22/20

Job Tracking No:

Due Date: 10/26/20

Created By: Marie Lajeunesse

Type: Stock *SOLD*

Description: SIOP

Note: DWG REV C IPP Rev: A New Issue 05-11-09 JLM IPP Rev: B Water jet/ ecn798 06-05-08 EC IPP rev.C back on haas 07.04.09 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	4 pcs		10/24/20	0.17	0.40	Waterjet - Flow		<i>on 20/10/05</i>
110	HAAS 4 Axis - B4B	4 pcs	10/24/20		1.00	0.96	HAAS - 1 - B4B		<i>20/10/05</i>
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs	10/24/20		0.00	0.00	QC 2 - 1		<i>20/10/05</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	4 pcs	10/24/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Small Fab - 2 - B4B	4 pcs	10/26/20	0.00 0.94	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
					Small Fab - 8 - B4B
					Small Fab - 9 - B4B
					Small Fab - Various 1 - B4B
150	QC 5	4 pcs	10/26/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22

D. 20-10-09

OCT 13 2020

				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 13 2020 DAS 40
				QC 5 - 61	9-89
				QC 5 - 81	
				QC 5 - 82	
160	Packaging 3-1 - Stock - B4B	4 pcs	10/26/20	0.00 0.00	Packaging 3 - 1 - B4B
		7 pcs m/h			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
170	QC 21 - SA	4 pcs	10/26/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77
					QC 21 - SA - 28

Part Op 100 - 1-Cut blanks.
 Descriptions: 110 - (HAAS CNC Vertical Machine)
 120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Small Fab) 1-Deburr if necessary 2-Install label as per Dwg D3212 3- polish abrasion scratches if necessary.. 4- Wrap in plastic wrap after inspection

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MACRLICS.125	1/8" Polycast li Sheet	3.8980 sf (.9745 ea)	100-Waterjet - Flow - 1	S151992-1 / S151992-2
D2728-1	Dart Logo Label Small	7 ✓ 4 pcs (1 ea)	140-Small Fab - 2 - B4B	S295088

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	MACRLICS.125	4	1,111	0
140-Small Fab - 2 - B4B	D2728-1	4	6,872	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 213322
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.731	✓		H-gage	
6.367	+/-0.005	6.365			↓	
0.625	+/-0.005	.629			↓	
Ø0.156	+0.005/-0.001	.156			Gage Pin	
R0.25	+/-0.030	.250			Rad gage	
8.150	+/-0.005	8.149			H-gage	
3.750	+/-0.005	3.749			↓	
0.313	+/-0.010	.317			↓	
15.14	+/-0.030	15.144			↓	
12.520	+/-0.005	12.518			↓	
6.260	+/-0.005	6.257			↓	
1.312	+/-0.005	1.316			↓	
0.313	+/-0.010	.319			↓	
3.750	+/-0.005	3.748			↓	
8.150	+/-0.005	8.149			↓	
8.462	+/-0.005	8.460			↓	
9.09	+/-0.030	9.095			↓	

Measured by: [Signature]	Audited by: B.	Preliminary Approval:
Date: 20/10/09	Date: 20-10-09	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S304744



Part: D3212-1

Job No: 213322

Serial No/Batch: S304744

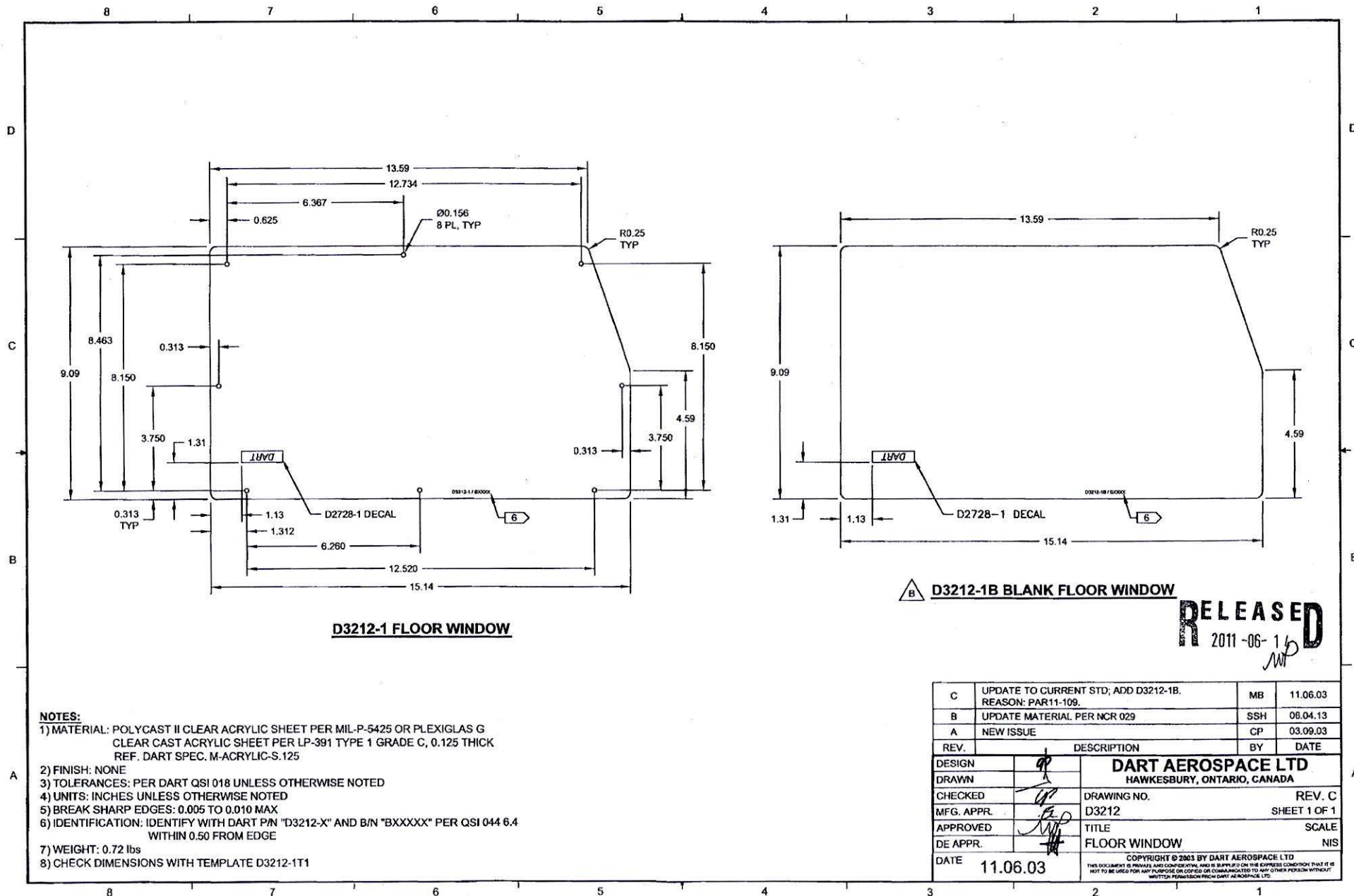
Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/05/20



RELEASED
2011-06-16